

Work Order ID 60147

Monday, June 28, 2010 9:03:48 AM



Page 1

Item ID: D350-607-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket, LH

Start Date: 6/28/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 7/9/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

10-6-28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D350-607-1	Rev A
------------	-------

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-607-041 CHG008

8/6/2014

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

50 197/8 ①

120

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D350-607

Seal support gusset seam with white sikaflex-291

Batch: *113519*

Expiry date:

10/11

=> m-k 10/07/13

(12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*****Ensure label for weight capacity is correct*****

8/10/07/13

(X)

140

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

Cm 7/13

150

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/10/07/14

(X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Date: 7/9/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-607-041								
	Location: <i>DPFT</i>								
170		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

*P 10/7/14 ①**MF 10-7-14*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 1



Required Date: 7/9/2010

Required Qty: 1.00

IPP Rev:0 as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-607-241 Basket Clamp Assembly		Manufactured	No			140	Each	1.0000	1	1			
<div> <div>  </div> <div> <div> <div>Location</div> <div>FG022</div> <div>59590</div> </div> <div> <div>Loc Qty</div> <div>1</div> <div>1</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div> </div> <div> <div>59212</div> <div>Per 7/13</div> </div> </div>													
D2221 350 Basket Base		Manufactured	No			110	Each	0.0000	1	1			
<div> <div>  </div> <div> <div> <div>Location</div> <div></div> <div></div> </div> <div> <div>Loc Qty</div> <div></div> <div></div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div> </div> <div> <div>60150</div> <div>M-L 10/07/13</div> </div> </div>													
D2512 Basket Lid 205/350		Manufactured	No			110	Each	0.0000	1	1			
<div> <div>  </div> <div> <div> <div>Location</div> <div></div> <div></div> </div> <div> <div>Loc Qty</div> <div></div> <div></div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div> </div> <div> <div>60151</div> <div>M-L 10/07/13</div> </div> </div>													
D2022-101 Spacer		Manufactured	No			110	Each	157.0000	2	2			
<div> <div>  </div> <div> <div> <div>Location</div> <div>ST504</div> <div>50746</div> <div>52325</div> </div> <div> <div>Loc Qty</div> <div>157</div> <div>57</div> <div>100</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div> </div> <div> <div>50746</div> <div></div> </div> </div>													
D2258-200 Placard 2001b		Manufactured	No			110	Each	0.0000	1	1			
<div> <div>  </div> <div> <div> <div>Location</div> <div></div> <div></div> </div> <div> <div>Loc Qty</div> <div></div> <div></div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div> </div> <div> <div>60135</div> <div>Per 7/18</div> </div> </div>													

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 60147

Parent Item: D350-607-041


Parent Item Name: Heli-Utility-Basket, LH

Start Date: 6/28/2010

Required Date: 7/9/2010


Start Qty: 1.00

Required Qty: 1.00

D2332-041	Manufactured	No	110	Each	10.0000	1	1
							
Lid Prop Assembly 6.69" long							


Location Loc Qty Loc Code

ST512	10	
57741	10	

D2530	Manufactured	No	110	Each	13.0000	1	1
							
Handle Weldment							


Location Loc Qty Loc Code

ST506	13	
59154	5	
59637	8	

D2535	Manufactured	No	110	Each	110.0000	2	2
							
Spring							


Location Loc Qty Loc Code

ST504	110	
56355	10	
58331	100	

D2537	Manufactured	No	110	Each	11.0000	2	2
							
Bushing							

Location Loc Qty Loc Code

ST504	11	
58429	11	

D2728-3	Manufactured	No	110	Each	0.0000	2	2
							
Dart Logo label							

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault/Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 60147

Parent Item: D350-607-041

Parent Item Name: Heli-Utility-Basket, LH

Start Date: 6/28/2010

Required Date: 7/9/2010

Start Qty: 1.00

Required Qty: 1.00

D2931

Manufactured No

110 Each

826.0000 2 2



Bumper



Handwritten signature

Location

Loc Qty

Loc Code

ST504

826

46064

826

AN3-16A

Purchased No

110 Each

137.0000 2 2



Bolt



Handwritten: 96064

Handwritten signature

Location

Loc Qty

Loc Code

ST352

137

113845

17

114523

20

114752

100

AN4-7A

Purchased No

110 Each

173.0000 2 2



Bolt



Handwritten: 113845

Handwritten signature

Location

Loc Qty

Loc Code

ST356

173

113226

173

AN4-22A

Purchased No

110 Each

283.0000 1 1



Bolt



Handwritten: 113226

Handwritten: 6/19/10 ①

Location

Loc Qty

Loc Code

ST359

283

111965

83

114523

100

114784

100

Handwritten: 111965

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Shop Packet Print

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Picklist Print

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Work Order ID: 60147

Parent Item: D350-607-041

Parent Item Name: Heli-Utility-Basket, LH

Start Date: 6/28/2010

Required Date: 7/9/2010

Start Qty: 1.00

Required Qty: 1.00

AN4-24A	Purchased	No	110	Each	35.0000	1	1	
Bolt								

Location Loc Qty Loc Code

ST360 35
112641 35

AN5-17A	Purchased	No	110	Each	135.0000	4		
Bolt								

Location Loc Qty Loc Code

ST339 135
114330 89
114784 46

AN960JD8	NAS1149DN832	Purchased	No	110	Each	0.0000	2	
	J							
Washer								

AN960JD416	NAS1149D0463J	Purchased	No	110	Each	0.0000	2	
Washer								

AN960JD416L	NAS1149D0416J	Purchased	No	110	Each	283.0000	2	
Washer								

Location Loc Qty Loc Code

ST346 283
110153 283

AN960JD516	NAS1149D0563J	Purchased	No	110	Each	0.0000	4	
Washer								

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Page 4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 60147

Parent Item: D350-607-041

Parent Item Name: Heli-Utility-Basket, LH

Start Date: 6/28/2010

Required Date: 7/9/2010

Start Qty: 1.00

Required Qty: 1.00

AN970-4
Washer

Purchased No

110 Each

89.0000

4

4

Location

Loc Qty

Loc Code

ST349

89

112991

89

MS20600-AD4W3
Cherry Rivets

Purchased No

110 Each

1,641.000

2

2

Location

Loc Qty

Loc Code

ST321

1641

106375

3

107939

822

111636

816

MS21042L3
Nut

Purchased No

110 Each

2,974.000

2

2

Location

Loc Qty

Loc Code

ST300

2974

114523

474

114718

500

114784

2000

MS21042L4
Nut

Purchased No

110 Each

2,771.000

4

4

Location

Loc Qty

Loc Code

ST300

2771

113422

68

114523

28

114718

675

114784

2000

Monday, June 28, 2010 9:03:53 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

Monday, June 28, 2010 9:03:53 AM

Page 6 16

Work Order ID: 60147



Parent Item: D350-607-041



Parent Item Name: Heli-Utility-Basket, LH

Start Date: 6/28/2010

Required Date: 7/9/2010

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

110

Each

627.0000

4

4



Nut

Per 7/8 ①

Location

Loc Qty

Loc Code

ST139

500

114813

500

ST300

127

114449

127

114813

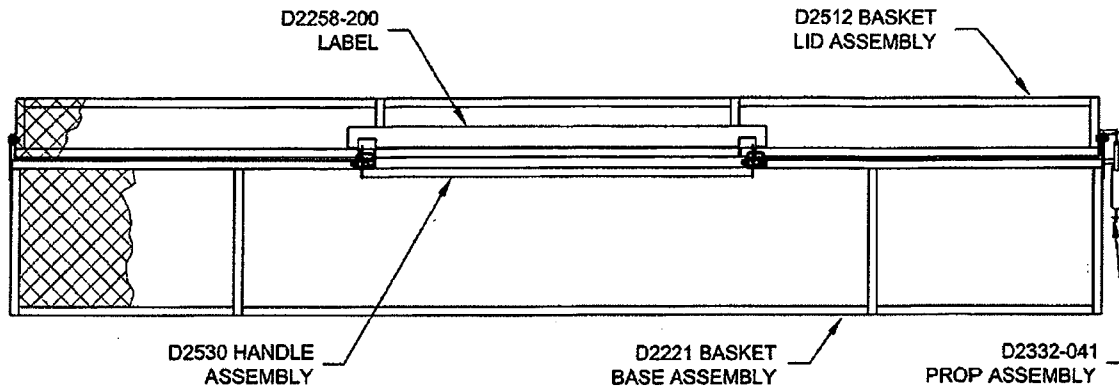
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

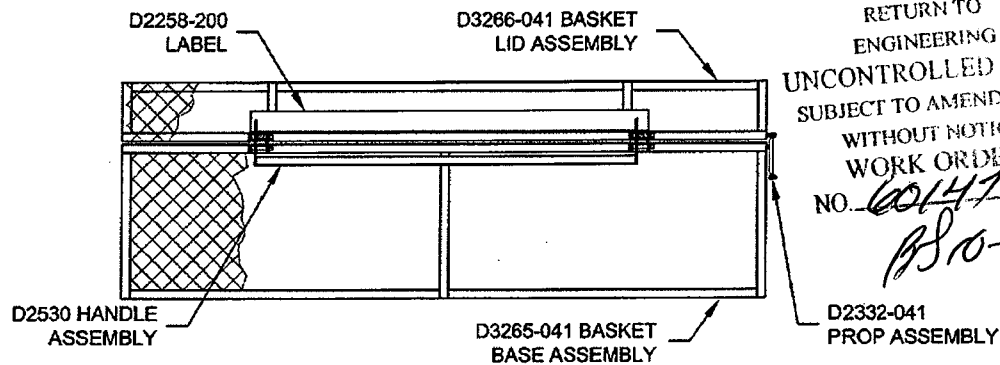
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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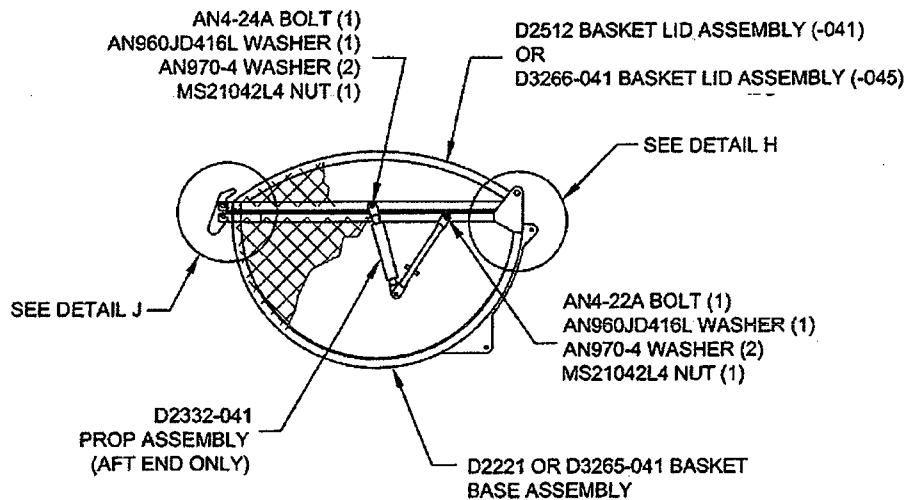
NOTE: Date & initial all entries



D350-607-041 HELI-UTILITY- BASKET™



D350-607-045 HELI-UTILITY- BASKET™



VIEW C-C
PROP ARM DETAIL

Figure 5 – Basket Replacement Parts

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Revision: **A**
Date: 10.03.10

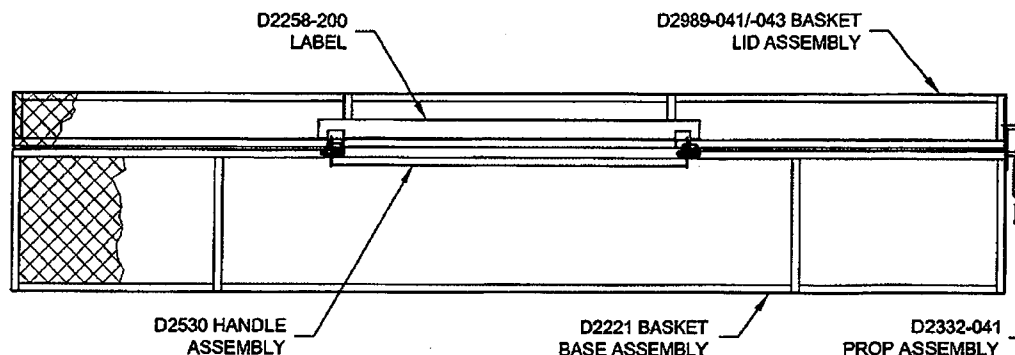
W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

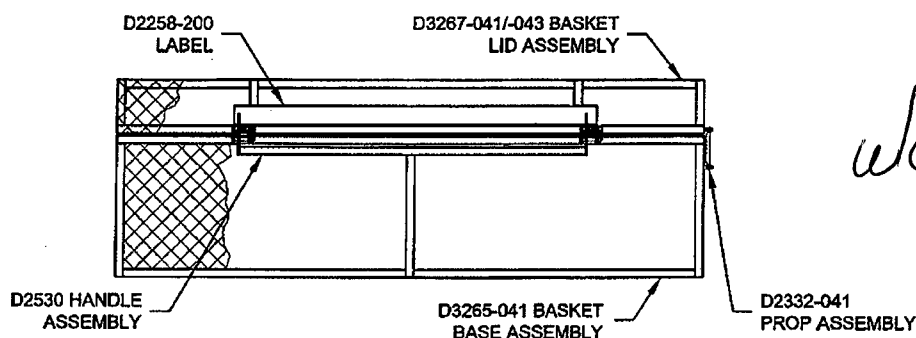
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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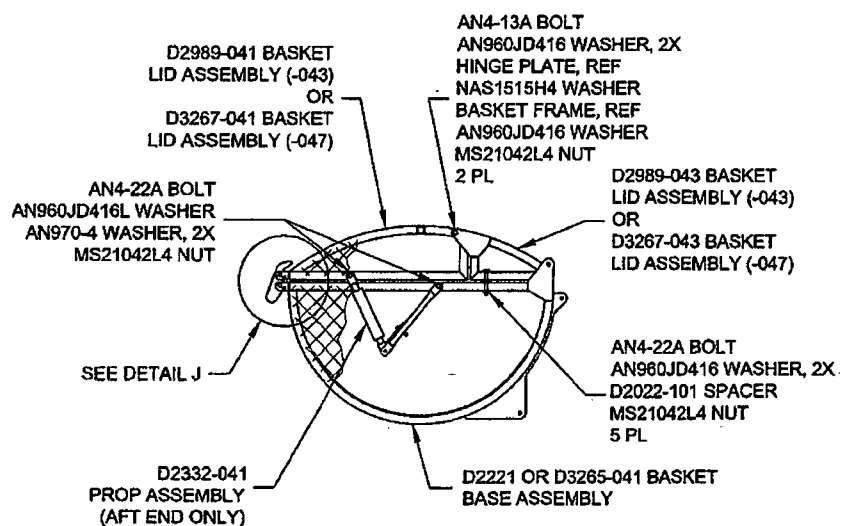
NOTE: Date & initial all entries



D350-607-043 HELI-UTILITY- BASKET™



D350-607-047 HELI-UTILITY- BASKET™



VIEW C-C
PROP ARM DETAIL

Figure 6– Basket Replacement Parts

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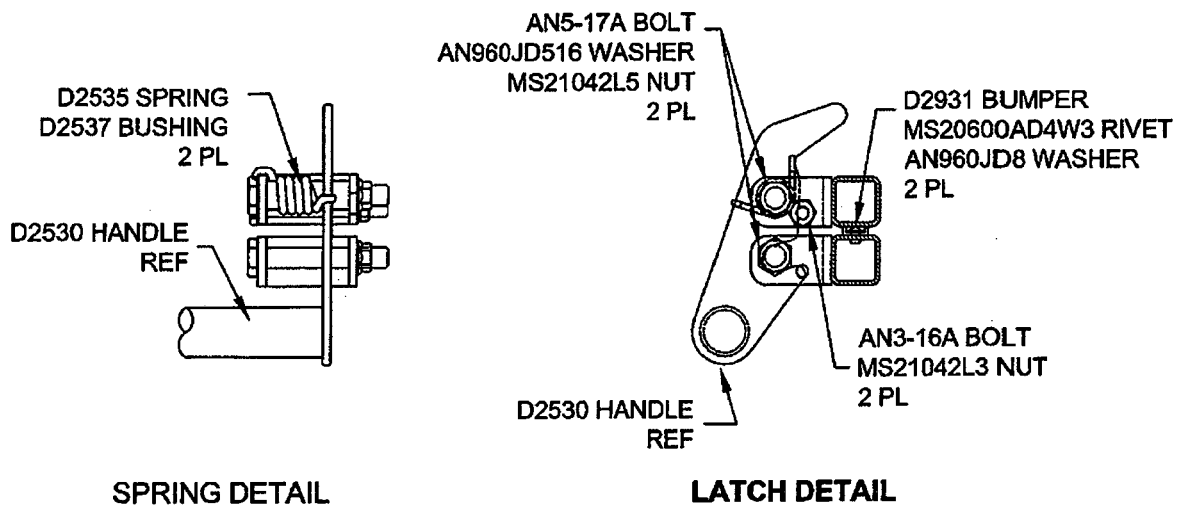
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DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

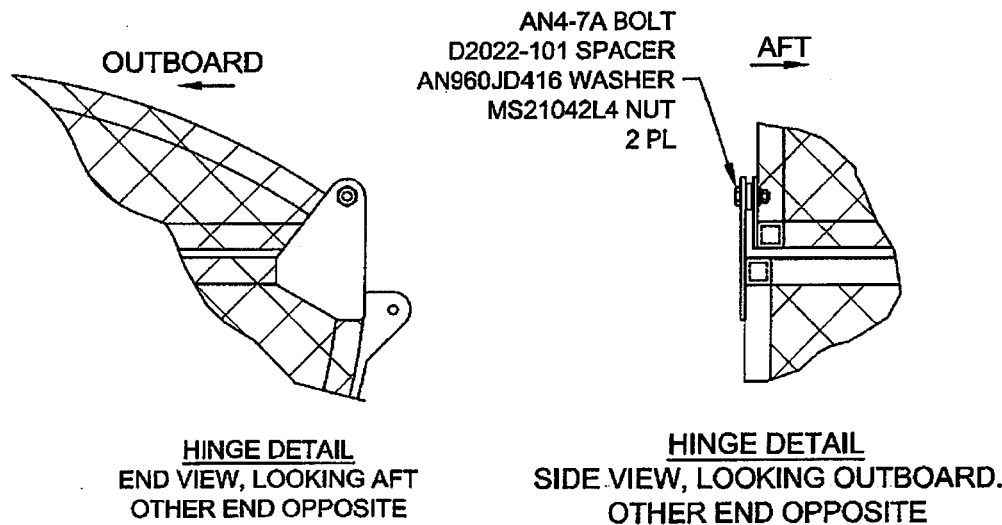
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				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**DETAIL J:
HANDLE WELDMENT**

w/060147



**DETAIL H:
HINGE**

Figure 7 – Basket Replacement Parts

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Setup Start



Revision ID:

Stop



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Required Date: 7/9/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date: 10-6-28

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D350-607-1

Rev A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-607-041 CHG008

CL 10/7/9

REFERENCE ONLY

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

120

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D350-607
Seal support gusset seam with white sikaflex-291

Batch: _____

Expiry date: _____